

Date: Wednesday, 10/3/2007 8:37:07 AM  
 User: Kim Johnston

## Process Sheet

44

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHORT STEP ASSEMBLY LOW SKID RH  
 Job Number : 34978  
 Estimate Number : 11117  
 P.O. Number : *N/A* Part Number : D350591216  
 This Issue : 10/3/2007 S.O. No. : *N/A* Drawing Number : D3168 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : LARGE FAB ASSY Drawing Revision : A  
 Previous Run : 25753 Material : *N/A*  
 Due Date : 10/30/2007 Qty: 3 Um: Each

Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est Rev: A 02.10.17 New issue KJ

Est Rev: B 06-06-19 Added D2732-030 AS PER DSI9294

JLM

Est Rev: C 06-06-27 Revised as per DSI9340 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



*KS 07.10.03*

Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-216 CHG002

2.0 D2622120C Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total : 1.5000 Each(s)

Pick:

Qty Part Number

Description

Batch

.5 D2622-120

Extrusion

*334016 = 2*

*3 32858 = 2*

*KS 07.10.18*

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120C extrusion to 57.090" long as per Dwg D3168

2-Drill extrusion as per Dwg D3168 using Jig DT8680 for rivets.(Use only 1st 6holes)

3-Deburr

*KS 07.10.18*

*KS 07.10.18*

*KS 07.10.18*

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*KS 07.10.18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate 334454

*SE 07.10.18*

3

6.0

D31691

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3169-1

Support

325200

*SE 07.10.18*

3

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8780, weld Fwd End Plate as per QSI 004 & Dwg D3168

A/R Aluminum Rod

M105058

M103794

3-Grind End Plate flush

*SE 07.10.18*

3

*SE 07.10.18*

3

*SE 07.10.23*

3

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07/10/23 (3)*

9.0

QC

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/10/23 (3)*

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Check Finish Coat as per QSI 005 4.1

*SAD 07-10-21 (3)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 34978

Part Number: D350591216

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



3X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 07/10/23

12.0

D30771

Step Leg



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3077-1

Step Leg Assy

326684

a.m

07.11.26

3

13.0

D31701

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3170-1

Spacer

323578

a.m

07.11.26

3

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS20600AD4W4

Rivet

M105953

a.m

07.11.26

3

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3168

a.m

07.11.26

3

16.0

QC3

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Au107

(3RM)

17.0

D30671

End Plate



Comment: Qty.: Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

335079

07.11.27

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 34978

Part Number: D350591216

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3168

A/R Aluminum Rod M105058

4-Grind End Plate flush

Q.M.

07-11-27

3

3

3

3

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

1D 07-11-28 (3)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/28 (3 RH)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

M.H.

07/11/28

(3 RH)

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M105914

M.H.

07/11/28

(3x RH)

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3168 and QSI 005 4.4

M106030

M.H.

07/11/29

(3x RH)

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

07/11/30 (3 RH)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 34978

Part Number: D350591216

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

D22301

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-1

Clamp

32163

SP

27.0

D22303

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-3

Clamp

335470

SP-

28.0

D2732

Rubber Extrusion



Comment: Qty.: 0.5000 f(s)/Unit Total : 1.5000 f(s)

Rubber Extrusion

Qty of 2 X 3"

Batch

B34717

AS 04/1/30

(X3)

29.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 1.8000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2856-400(7.2") Abrasion Strip

334642

SP

30.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A

Bolt

W165408

4405408

7/11/29 SP (3X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 34978

Part Number: D350591216

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN411A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN4-11A

Bolt

*M102280 - SB*

32.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Batch: *M106043*

*sq*

33.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

*M105792*

*sq*

34.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416

Washer

*M105906*

*sq*

35.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

*M102658*

*sq*

36.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4

Nut (or -4)

*M105054*

*7/11/29 sq (32)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: DD Date: 5/12/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 34978

Part Number: D350591216

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

6/11/30 (X3)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-216

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

B

*[Handwritten signature]*

6/11/30

(X3)

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/07/12/04

Job Completion



12/12/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3168</b>	REV. A SHEET 1 OF 2
DATE <b>02.09.11</b>		TITLE <b>STEP ASSEMBLY, LOW SHORT</b> SCALE NTS	
A	02.09.11	NEW ISSUE	

**RELEASED**  
02.09.20 *H*

Part No.	Description	QTY -041	QTY -042
D3168-041	Step Assembly, Low Short (LH)	X	
D3168-042	Step Assembly, Low Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3067-1	END PLATE	2	2
D3077-1	STEP LEG	2	2
D3169-1	SUPPORT	1	1
D3170-1	SPACER	2	2
MS20600AD4W4	RIVET	12	12

**GENERAL NOTES:**

- 1) -041 SHOWN, FOR -042 INSTALL D3169-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WITHOUT NOTICE  
WORK ORDER  
NO. **34978**

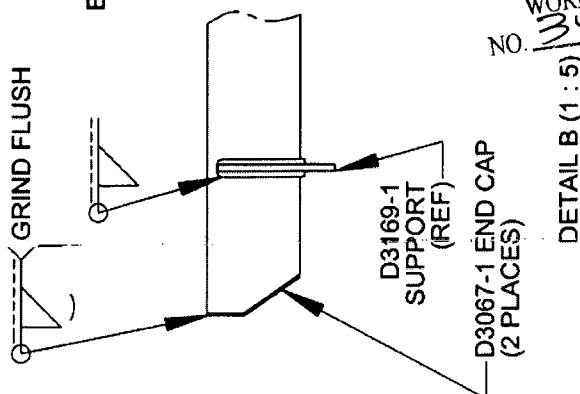
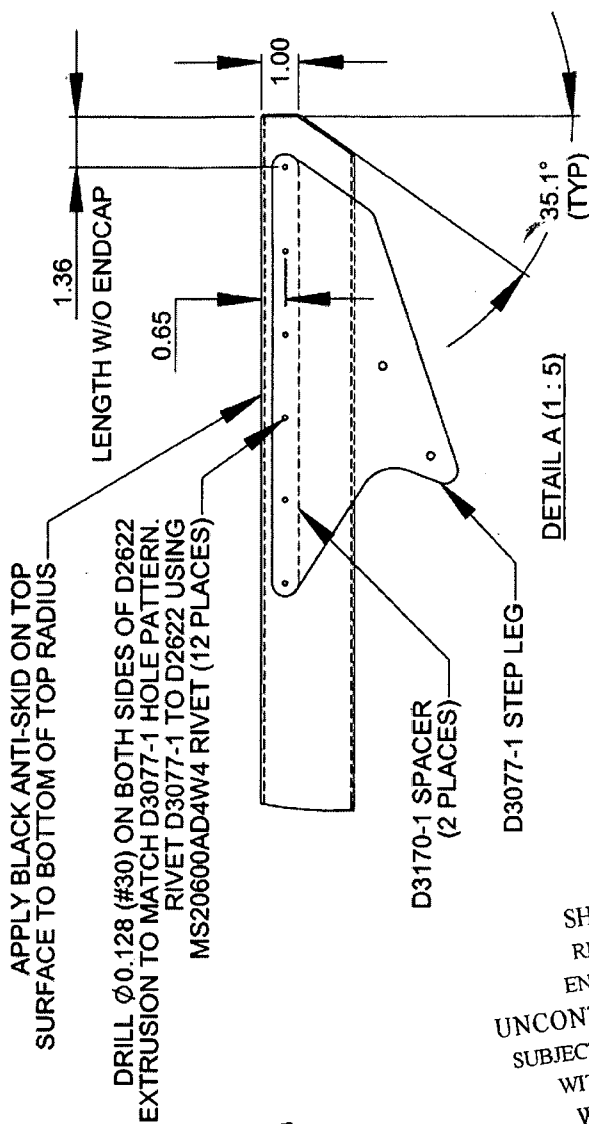
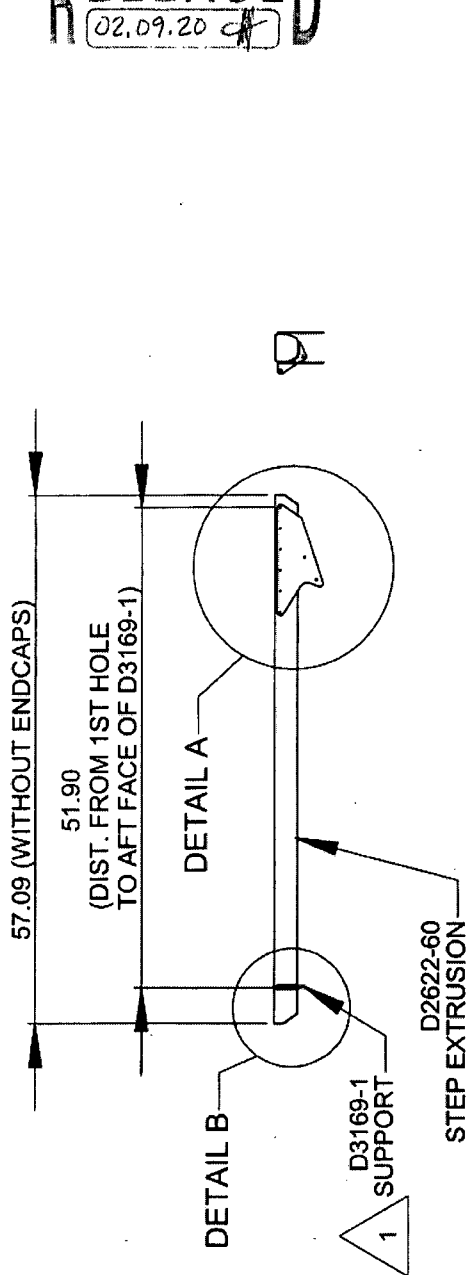
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3168	REV. A SHEET 2 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, LOW SHORT	SCALE 1:20

RELEASED  
02.09.20 *[Signature]*



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